



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

653 355
SWA6A-100
Job Sheet 189712



Part No: SWA6A-100

Job Qty: 4 pcs

Part Name: Lower End



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 2/15/19

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG SWA6A-100 Rev7 IPP Rev A 17.11.15 New issue

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	2/15/19	2/15/19	0.00	0.40	Bandsaw - 1		[Signature]
110	NLX 2500SY - B4B	4 pcs	2/15/19	2/15/19	0.00	4.00	NLX 2500SY - 1 - B4B		
120	QC 2	4 pcs	2/15/19	2/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		[Signature]
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S159346



Part: SWA6A - 100

Job No: 189712

Serial No/Batch: S159346

Revision: 7

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/05/19

5159 346

130 QC 8	4 pcs	2/15/19	0.00 0.00	QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	H 1903-11
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
140 Packaging 3-1 - Stock - B4B	4 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS 28 9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	4 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21	

Plex 1/29/19 3:14 PM dart.leroux.jason

MAR 11 2019

Part Op 100 - (Bandsaw) Cut blanks to 5.90".

Descriptions: 110 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per folio FB703 FOLIO REV: _____ DWG REV: _____

2-Debur

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Identify as per dwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.500	17-4 SS H1150 Round Bar 2.500"	1.9600 ft (.49 ea)	100-Bandsaw - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-H1150-R2.500	2	0	0

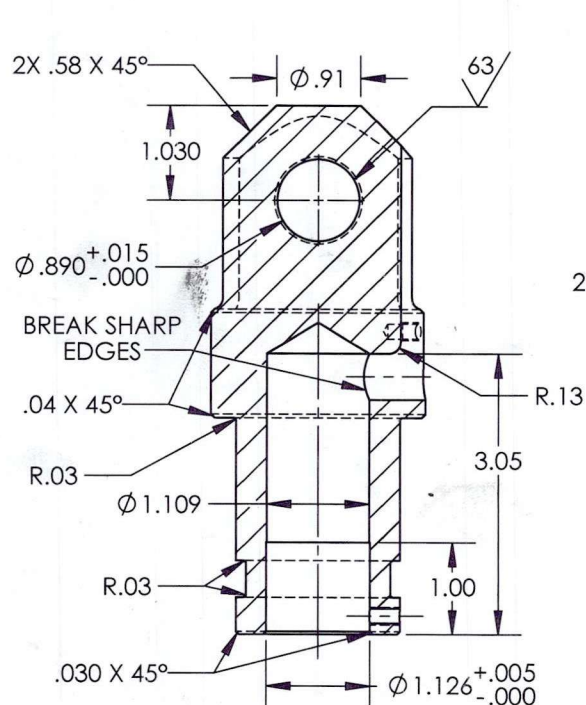
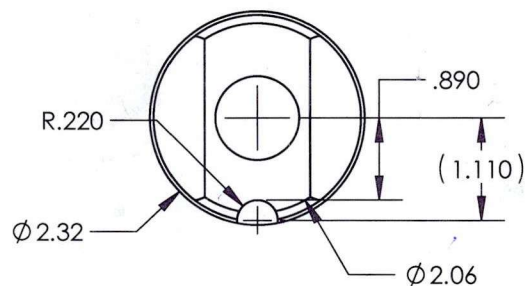
Part Specifications

Specifications could not be found.

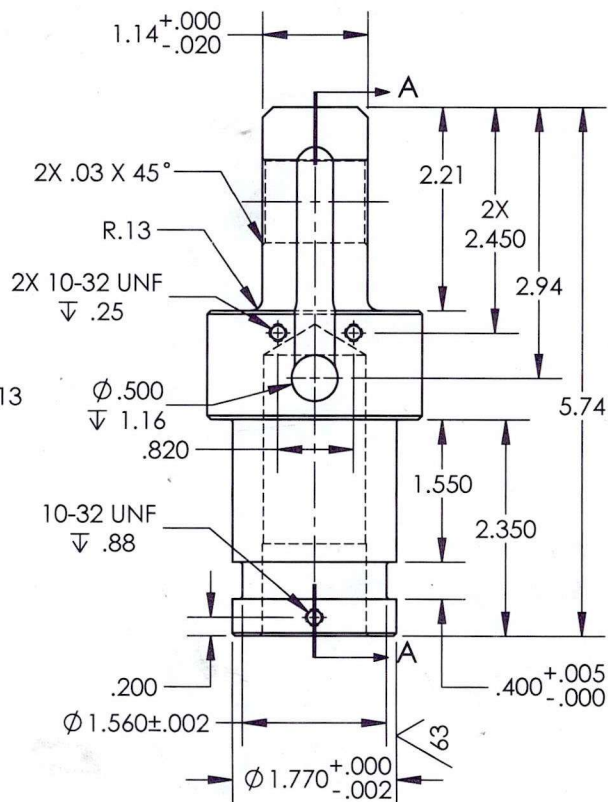
Plex 1/29/19 3:14 PM dart.leroux.jason

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6		AS DRAWN BY CANAM.	11/15/2012	JAG	
7	15-0088	CH'D DIMENSION OF TOP FLANGE WAS 1.14 IS 1.14 +.000 -.020.	4/16/2015	RJC	JAG



SECTION A-A



DART AEROSPACE	
TITLE LOWER END	
DWG NO. SWA6A-100	REV 7
MAT'L SS 17-4, H1075, H1150	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
SCALE 1:2	DATE 2/1/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA6A-100	1	LOWER END	SS 17-4, H1075, H1150	Ø2-1/2 X 5-7/8

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :		Sequence #:		QTY Affected :		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:							

DART AEROSPACE LTD		Work Order:	189712
Description: Lower End		Part Number:	
Inspection Dwg: SWA6A-100		Rev: 7	Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.91	±.01	.910			Vern LPID	
.58 x 45°	±.01 x .5°	.58 x 45°				
1.030	±.005	1.0315				
Ø.890	+0.015 / -0.000	.893				
.04 x 45°	±.10 x .5°	.04 x 45°				
R.03	±.01	.032			Rad gauge	
Ø1.109	±.005	1.105			Vern LPID	
R.03	±.01	.02			Rad gauge	
.030 x 45°	±.005 x .5°	.032 x 45°			Vern LPID	
Ø1.126	+0.005 / -0.000	1.128				
3.05	±.01	3.051			H-gauge	
R.13	±.01	.125			Rad gauge	
1.00	±.01	1.006			Vern LPID	
R.220	±.005	.219			Rad gauge	
Ø.232	±.01	2.319			Vern LPID	
Ø2.06	±.01	2.059				
.890	±.005	.889				
1.14	+0.000 / -0.020	1.130				
.03 x 45°	±.01 x .5°	.035 x 45°				
R.13	±.01	.125			Rad gauge	
10-32 UNF	GO-NOGO	GO			GO-NOGO gauge	
Ø.500	±.005	.499			Vern LPID	
.820	±.005	.825				
10-32 UNF	GO-NOGO	GO			GO-NOGO gauge	
.200	±.005	.197			Vern LPID	
Ø1.560	±.002	1.560				
Ø1.770	+0.000 / -0.002	1.769				
.400	+0.005 / -0.000	.402				
2.350	±.005	2.350			H-gauge	

Measured by:	19-03-04	Checked by:	20 9-89	QC Inspector:	
Date:		Date:	19-03-11	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	